

Work Order ID 50531

July 14, 2009 11:14:25 AM



Page 1

Item ID:	D3120-1	64	Accept		Setup	Start	
Revision ID:	B					Stop	
Item Name:	Cover						
Start Date:	7/16/09	Start Qty:	4.00		Cust Item ID:		
Required Date:	7/24/09	Req'd Qty:	4.00		Customer:		
Reference:							

Approvals:	Process Plan:	MF	Date:	09-07-15	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3120	Rev B								

110		HAAS CNC VERTICAL MACHINING #1	0.00						
	Waterjet	Memo	0.00						B 9-8-12
	FLOW CNC Waterjet	FLOW WATER JET 1-Cut as per Dwg D3120 Dwg Rev: <u>B</u> Prog Rev: <u>B</u>							
		2- Deburr if necessary							B 9-8-12
120		QC2- Inspect parts off machine FAI/FAIB	0.00						
	QC	Memo	0.00						
	Quality Control								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50531

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Item ID: D3120-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Cover

Start Date: 7/16/09

Start Qty: 4.00



Cust Item ID:

Required Date: 7/24/09

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

(135) Bend bs per dng

(136) QC 5 => SUT 08/27

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

10:00AM

FINISH TIME:

3209

OVEN TEMPERATURE:

BR 0908-27 (6)

JL 09/08/28 G

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50531

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Page 3

Item ID: D3120-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Cover

Start Date: 7/16/09

Start Qty: 4.00



Cust Item ID:

Required Date: 7/24/09

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BR 09-08-28



170



Packaging

Packaging

Identify as per dwg & Stock Location 237

Memo

0.00

0.00

9/8/28 @ SP

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/08/31 HJ

09-8-28 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 50531

Parent Item: D3120-1RevB

Parent Item Name: Cover


Comments:

Start Date: 7/16/09

Required Date: 7/24/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			110	sf	111.0100	0.9006			
<div>  </div>												
2024-T3 .032 sheet												

 6
 9-8-09

Warehouse Loc Qty Loc Code

Location


Main Warehouse

MAT

111.01

102942	1.5
105555	5
106272	8.47
108595	3
109240	7.02
110778	34.02
111699	49
18147	3

110778

 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

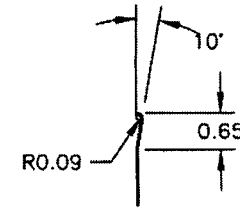
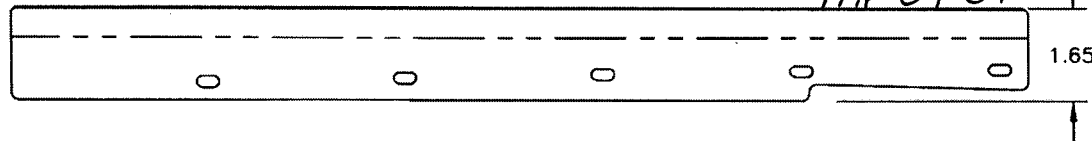
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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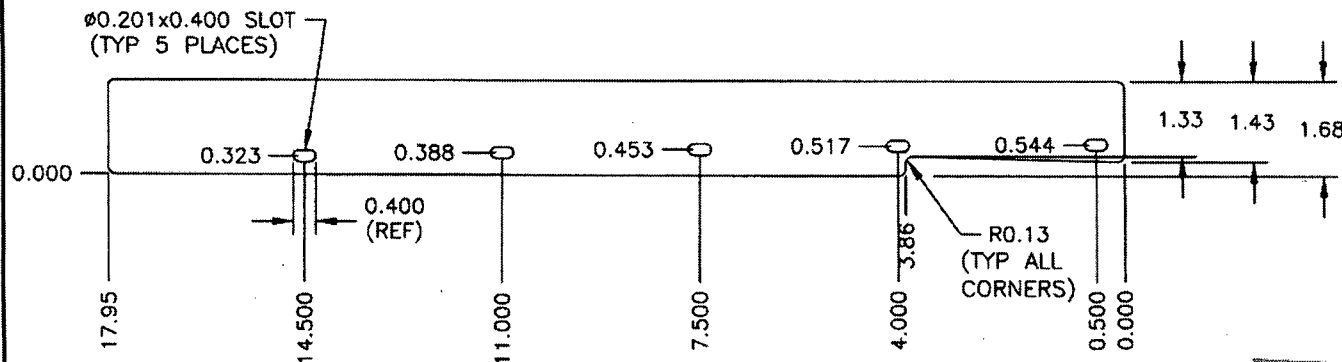
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WITHOUT NOTICE
WORK ORDER
NO. 50531
MF 09-07-15



BEND DETAIL

D3120-1 COVER (BEND AS SHOWN, REPLACES PREMIER P/N B30-23000-229)
D3120-2 COVER (BEND OPPOSITE, REPLACES PREMIER P/N B30-23000-230)



D3120-1/-2 COVER, FLAT PATTERN

D3120-1/-2 NOTES

- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.032 THICK (REF DART SPEC. M2024T3S.032)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER ON INSIDE SURFACE

RELEASED
04-11-23

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. B
04.10.18	COVER	SHEET 1 OF 2
A	02.04.15	NEW ISSUE
B	04.10.18	ADD PART MARKING
		SCALE
		NTS

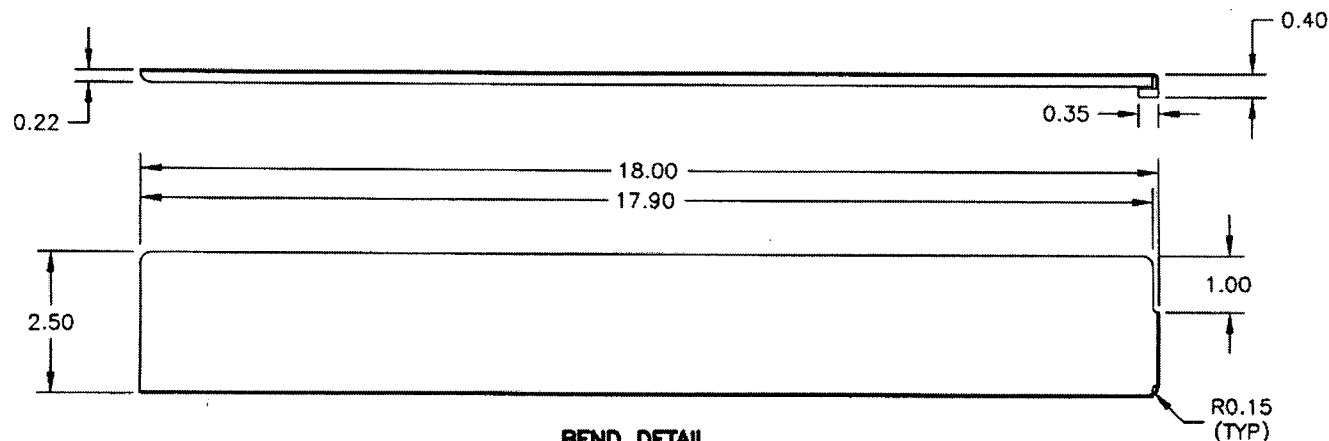
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DART

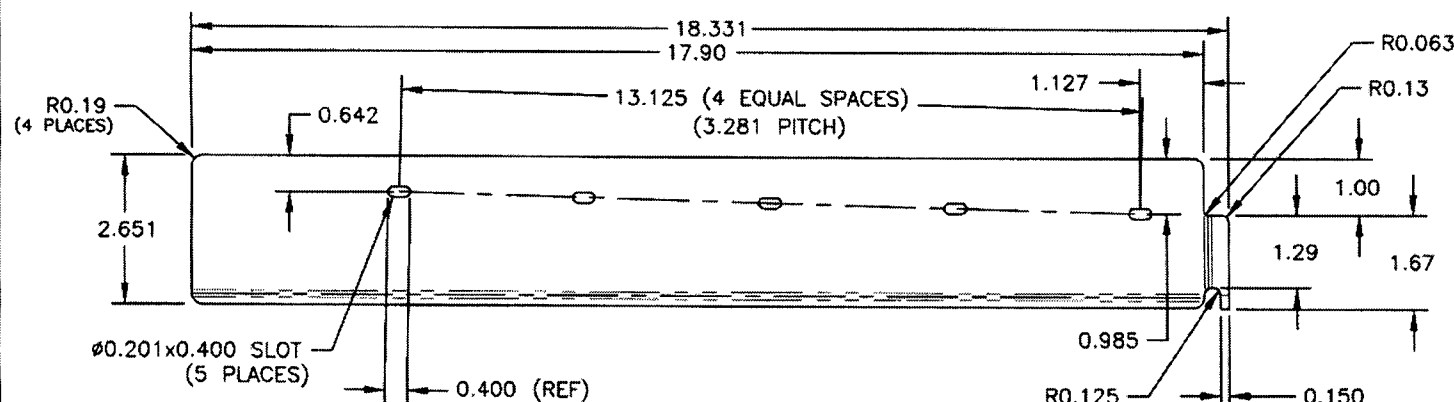


DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. B
DATE	04.10.18	TITLE	COVER	D3120	SHEET 2 OF 2
		SCALE	NTS		



BEND DETAIL

D3120-3 COVER (BEND AS SHOWN. REPLACES PREMIER P/N B30-23000-231)
D3120-4 COVER (BEND OPPOSITE. REPLACES PREMIER P/N B30-23000-232)



D3120-3/-4 COVER. FLAT PATTERN

D3120-3/-4 NOTES

- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.032 THICK (REF DART SPEC. M2024T3S.032)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER ON INSIDE SURFACE

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04.11.13

mf 09-07-15